

# Work Order ID 86344

June-27-12 3:20:05 PM

**\*86344\***

Page 1

Item ID: D2672

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearpaw 13" X 24", 206

Start Date: 27/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

15

Approvals:

Process Plan: MLJ

Date: 12/06/28

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2672	Rev B1					(4)			
120		0.00							
<b>*120*</b>	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per File D2672_BLANK								
UHMW 1"									
130		0.00							
<b>*130*</b>	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA791 and Dwg D2672. Identify as D2672 3-Deburr								
140		0.00							
<b>*140*</b>	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B12-7-5

12-07-13 (x4)

12-07-13 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86344

**\*86344\***

Page 2

June-27-12 3:20:05 PM

Item ID: D2672

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearpaw 13" X 24", 206

Start Date: 27/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC8- Inspect parts - second check

0.00

**\*150\***

OK 12/07/16

4 10

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location:

0.00

**\*180\***

Packaging

Memo

PP 86341

0.00

Packaging

Packaging

12/14/16 (4)

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

12/17/18

MF 12-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-27-12 3:20:09 PM

Page 1

Work Order ID: 86344

\*86344\*

Parent Item: D2672

\*D2672\*

Parent Item Name: Bearpaw 13" X 24", 206

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 4.00

Required Qty: 4.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	72.0100	3.6	14.4	④		

\*MUHMWB10\*

UHMW 1" Black

\*\*

B12-7-5

Location	Loc Qty	Loc Code
MAT018	48.9	
120972	1	
121346	27.1	
121954	20.8	
MAT019	1.5	
118814	1.5	
ST052	21.60999474	
121277	12.8	
121278	8.80999474	

122286

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	86344
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D2672
<b>Inspection Dwg:</b> D2672	<b>Rev:</b> B1	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	23.750	+/-0.030	23.750	✓		Tape	RT-10
B	12.750	+/-0.030	12.750	✓		"	
C	4.250	+/-0.010	4.253	✓		vern	RT-4
D	2.000	+/-0.030	2.002	✓		"	
E	9.000	+/-0.010	9.000	✓		Tape	RT-10
F	0.375	+/-0.030	.380	✓		vern	RT-4
G	9.000	+/-0.010	9.000	✓		Tape	RT-10
H	Ø0.260	+0.005/-0.000	.260	✓		vern	RT-4
I	Ø0.93	+/-0.030	.930	✓		"	
J	0.300	+0.030/-0.000	.315	✓		dept gage	RT-6
K	0.625	+/-0.030	.623	✓		vern	RT-4
L	0.063 x 45°	+0.030/-0.010	.062	✓		"	
M	0.250	+/-0.010	.242	✓		mic deep	118120
N	5.500	+/-0.030	5.506	✓		vern	RT-4
O	R0.250	+/-0.030	.250	✓		rad gage	
P	0.200	+/-0.030	.195	✓		dept gage	RT-6
Q	0.25 x 45°	+/-0.030	.267	✓		vern	RT-4
R	0.950	+0.030/-0.010	.948	✓		"	
S	0.375	+/-0.010	.373	✓		"	

<b>Measured by:</b>	KS	<b>Audited by:</b>	amk	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	12 07 13	<b>Date:</b>	12/07/14	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

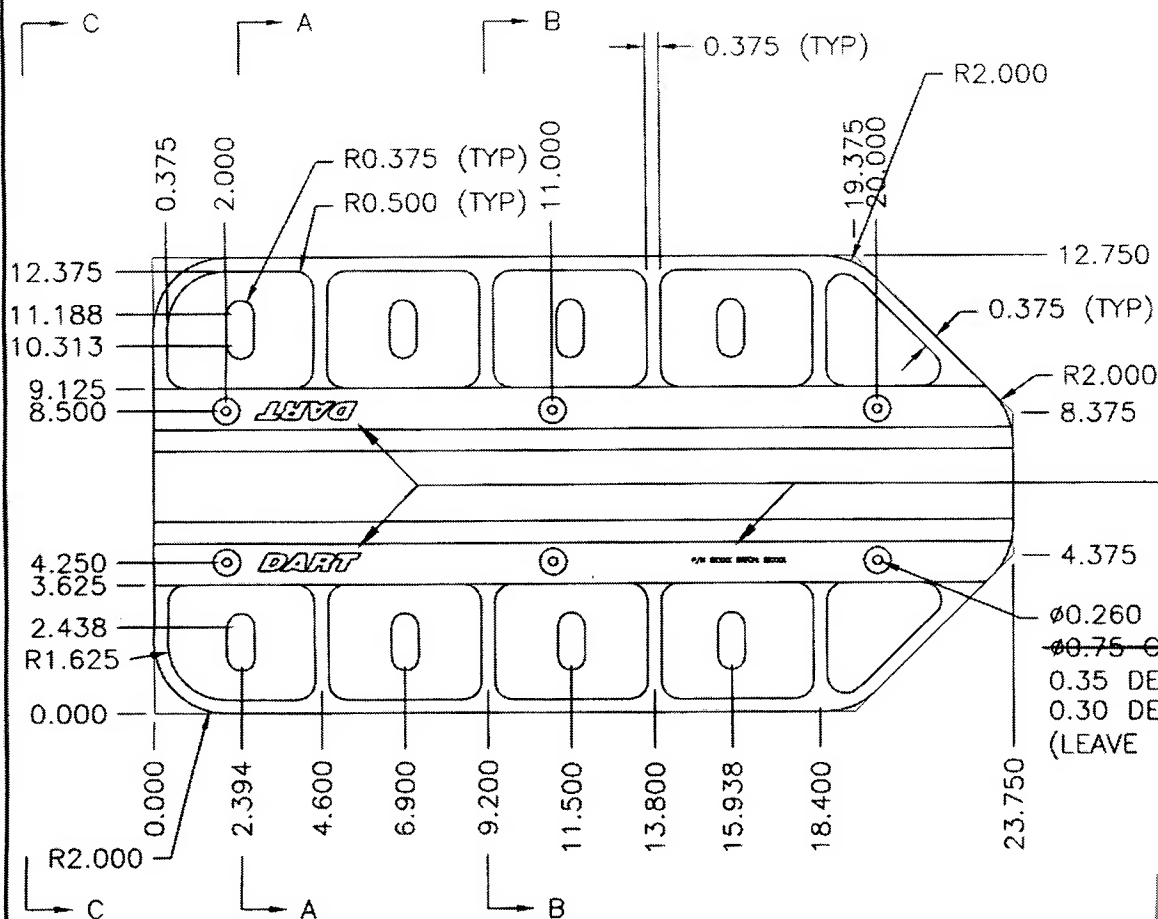
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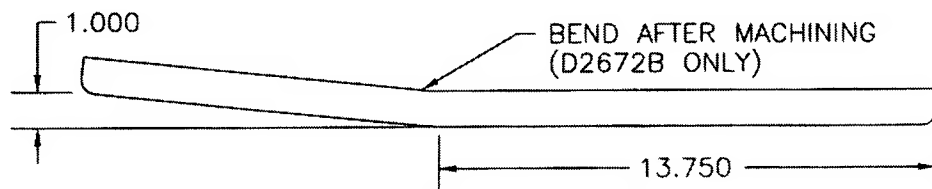
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ENGRAVE LOGO TO  
MAX DEPTH OF  
0.012. ENGRAVE  
PART AND BATCH  
NUMBERS TO MAX  
DEPTH OF 0.010.  
(TYPICAL LOCATION  
AS ILLUSTRATED)

0.260 (TYP)  
~~0.75 C'BORE~~  $\phi$ 0.43 C'BORE  
0.35 DEEP FROM TOP (MIN.)  
0.30 DEEP FROM BOTTOM  
(LEAVE 0.300 MIN.)

FLAT PATTERN



D2672F: FLAT BEARPAW  
D2672B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

EFFECTIVE	DEOS
9/14/3	

RELEASED  
98.06.17 KS

DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. B	
KE	KE	D2672		SHEET 1 OF 2	
DATE		TITLE		SCALE	
98.05.19		BEARPAW		1:5	
A	97.04.08	NEW ISSUE			
B	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50			
B1	98.05.19	$\phi$ 0.43 WAS $\phi$ 0.75			

SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86344 MLC  
12/06/28



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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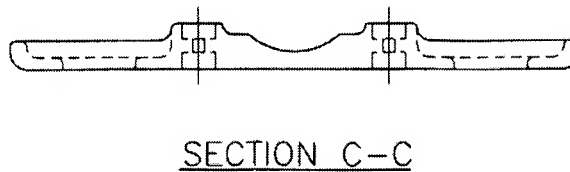
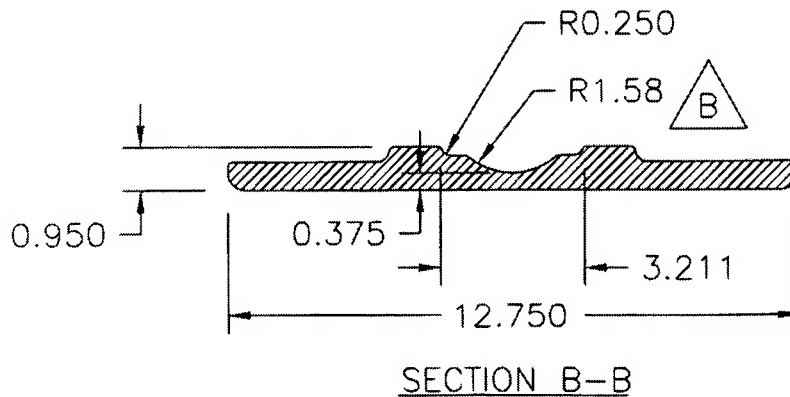
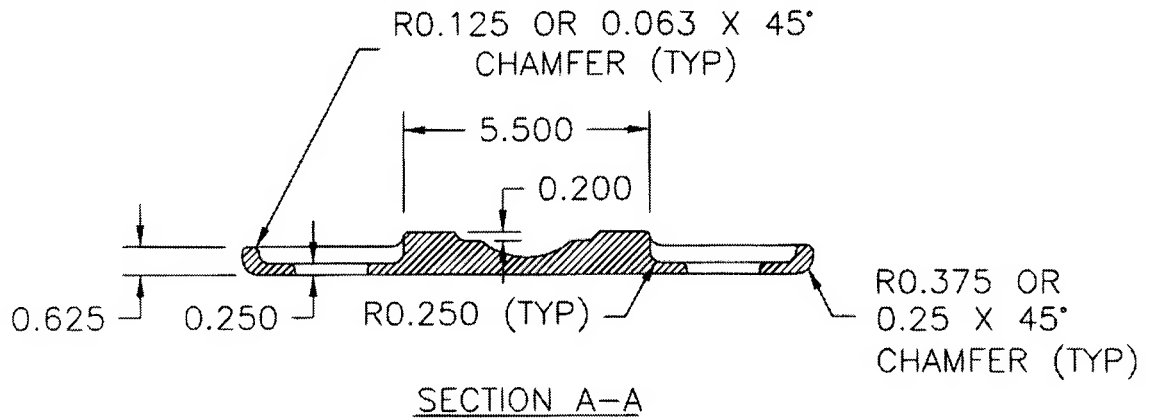
**NOTE:** Date & initial all entries

86344



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>DM</i>	APPROVED <i>KE</i>	DRAWING NO. D2672	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED  
24.06.17 KE



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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